

Work Order ID 163905

163905

Item ID: D3903-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 7/19/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 11 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3903	B

100

0.12

100

Hardinge

Memo

0.85

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA813 & DWG D3903,

FOLIO REV: AA

DWG REV: B

2-DEBURR AS REQUIRED

40 0 9-89 17/07/23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.40

Quality Control

40 0 9-89 17/07/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Work Order ID 163905

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163905

Page 2

Item ID: D3903-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 7/19/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 7/24/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						40	0		45
QC	Memo	0.80							9-89
Quality Control									17-07-23
125		0.00							
125						40	0		2017/07/24 AP
Skidtubes	Memo	0.07							
Skidtubes	Clean spacers with Ultra Aluminum Cleaner								
	Batch: 163905 N/A								
130	Identify as per dwg & Stock Location: LG001	0.00							
130						40	0		2017/07/24 AP
Packaging	Memo	0.40							
Packaging	LOCATION : LG001								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
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OTHER : ☐					

Work Order ID 163905

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163905

Page 3

Item ID: D3903-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Spacer

Stop ***NS2***

Start Date: 7/19/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 7/24/2017 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

4.00

Quality Control

DAS
21
9-89

JUL 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 163905

163905

Parent Item: D3903-1

D3903-1

Parent Item Name: Spacer

Start Date: 7/19/2017

Required Date: 7/24/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	60.0001	0.345	14.52632			DAS
									**				33
												9-89	
												17/07/23	

M6061T6T0.375W.058

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT013

60.0001

m137169

0.0001

m137477

60

15,05'

DQA: _____ Date: _____

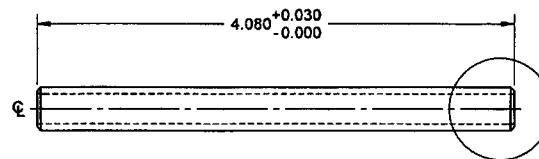
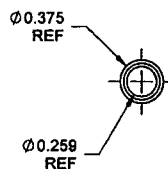


WORK ORDER NON-CONFORMANCE / UPDATE

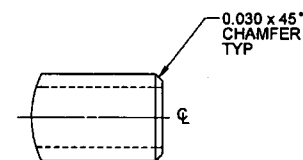
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OTHER : _____					



B2-1
DETAIL A



DETAIL A C3-1
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163905

D3903-1 SPACER

JUL 11 2017

RELEASED
8/6/15

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SEAMLESS TUBING 0.375" OD x 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
OR ASTM B210 OR ASTM B241 (REF DART SPEC. M6061T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

B	CORRECT TYPO Ø0.375 WAS Ø0.313 (ZNA6-1)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3903** REV. B
SHEET 1 OF 1

TITLE **SPACER** SCALE NTS

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